PS 系列

数控液压冲剪复合机
CNC Hydraulic Punch-shearing Combined Machines PS Series

PS31250数控液压冲剪复合机
CNC Hydraulic Punch–shearing Combined Machine **PS31250**

国内首家研制生产的集数控转塔冲床和直角剪床于一体的新型冲剪复合机，将板材冲孔、成型及剪切过程一次完成，由原材料直接生成工件，替代了传统的冲剪分离加工工序，减少加工时间约60%，节省材料达10%，极大提高了材料的利用率、加工效率，降低了生产成本。并可提供立体仓库、上料、下料、分选、堆垛等装置，进一步拓展该机的自动化程度。

数控液压冲剪复合机在行业中处于领先水平，达到了国外同类产品的先进水平。

CNC turret punch press and the right-angle shearing form CNC Hydraulic Punch-shearing Combined Machine with the newly-developed in China. The machine was conceived with process improvement as its guiding principle, and every detail was designed to provide the finest in material handling, punching and shearing, programming, diagnostics and controls to facilitate both consistent quality and flexible manufacturing. The machine is several times than traditional Punch-shearing separate working procedure, and reducing machining time 60%, scanty material 10%, also improve processing efficiency and reduce production costs. Provide destacking store, automatic loading, automatic unloading, automatic unloading onto stacker, table that can be joined together.

The machines are at domestic leading level and reach the advanced level of overseas the same kind products.

主要技术参数 Main Technical Specifications

参数　Specification	型号　Type	PS31250	PS31550
公称压力（冲／剪）　Nominal force (Punching/Shearing)	kN	300/280	300/280
最大加工板材厚度（冲／剪）Max. thickness (Punching/Shearing) (Mild steel)	mm	6/4	6/4
最大加工板材尺寸（一次重定位）　Max. sheet size (One reposition)	mm	1250×5000	1500×5000
最大加工板材重量　Max. workpiece weight	kg	150	150
滑块行程（冲／剪）　Ram stroke (Punching/Shearing)	mm	30/90	30/90
滑块最大运行速度（冲／剪）　Max. ram speed (Punching/Shearing)	h.p.m	900/105	900/105
最大送料行程（X／Y）　Max. moving stroke	mm	2500/1400	2500/1500
转盘最大转速　Max. turret rotation	r/min	30	30
模位数（含2套自转模）　Number of stations (2 index stations)	set	32	32
最大单次冲孔尺寸　Max. one punching diameter	mm	88.9	88.9
最大剪切工件尺寸　Max. shearing workpiece size	mm	800×1250	800×1500
加工精度　Accuracy	mm	±0.1	±0.1
数控轴数　Controlling axes	piece	5	5
机床重量　Machine weight	T	25	26
外形尺寸　Outline dimensions	mm	4990×5200×2300	5100×5200×2300